

Date: Tuesday, 1/31/2006 11:04:03 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GHW MEDIUM BELL
Job Number	: 25683		
Estimate Number	: 12129		
P.O. Number	: N/A	Part Number	: D412729041
This Issue	: 1/31/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: DSK 092 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25682	Drawing Revision	: B
	Type : LARGE FAB ASSY	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 2/28/2006
Checked & Approved By	: [Signature] 06.01.31	Qty:	1 Um: Each
Comment	: Est Rev:E 05.04.13 LPS3 rust inhibitor added; Hardware P/N's changed KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D27287	Decal
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Label B22554

CPL 06.02.09



2.0	D3233041	Wheel Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-041 Wheel Assembly B23577C

CPL 06.02.09



3.0	D32331	Inside Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-1 Inside Washer B23040

CPL 06.02.13



4.0	D32333	Outside Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-3 Outside Washer B23041

CPL 06.02.13



W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Job Number: 25683

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33091

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3309-1 Label B22109

CPL 06.02.13 (X)

6.0

D33093

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3309-3 Label B23768

CPL 06.02.13 (X)

7.0

D3330041

Frame Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3330-041 Frame Weldment B23016C B25639

CPL 06.02.10 (X)

8.0

D3331041

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3331-041 Handle Assembly B23568
B23769B

CPL 06.02.09 (X)

9.0

D3332041

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-041 Long Pin Assembly B23018 B23770

CPL 06.02.09 (X)

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Job Number:



Seq. #: Machine Or Operation: Description :

10.0 D3332043 Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-043 Short Pin Assembly B23019/B23771

CPL 06.02.09 (2)

11.0 D33331 Base Plate Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-1 Base Plate B23055 ✓

CPL 06.02.09 (2)

12.0 D33333 Sliding Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

~~1 D3333-1 Base Plate B23055~~

3 D3333-3 Sliding Plate B25684

CPL 06.02.23

13.0 D33335 Rail



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3333-5 Rail B23056

CPL 06.02.09

14.0 D33341 Wheel Shaft



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3334-1 Wheel Shaft B25684/B23022B

CPL 06.02.10 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D33351

Short Spring



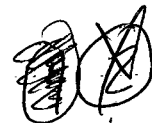
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-1 Short Spring B22256

CPL 06-02-09



16.0

D33353

Long Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-3 Long Spring B22256

CPL 06-02-09



17.0

D33361

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3336-1 Jack B23772A

CPL 06-02-10



18.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD416 Washer M18431

CPL 06-02-13



19.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CP-21 1/8" Cotter Pin 2" long, Span M16306

CPL 06-02-13



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Job Number: 25683

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

HC12

1/4-20 UNC x 1" Hex Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span

N/A

6

21.0

HC29

5/16-18 UNCx1.5 Hex Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof

M19705

CPL 06-02-13

22.0

HC153

3/8"-24UNFx1.25 Hex Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 HC-153 3/8"-24 UNF x 1.25" long Hex Bolt, Span

M17356

CPL 06-02-10

23.0

HN120

HEX SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HN-120 1" Slotted Nut, Prof

M18162

CPL 06-02-10

24.0

HN177

5/16-18UNC Nylon LockNut



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HN-177 5/16"-18 UNC Nylon Lock Nut, Span

M16626

CPL 06-02-13

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

HX15

1/4-20 UNCx3/4 S.H.C.S.



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span M16626

CPL 06.02.13



26.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5) M1907B

CPL 06.02.13



27.0

2333

1 1/4" Type B Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 2333 1 1/4" Type B Flat Washer (Wide), Span M16154

CPL 06.02.10



28.0

18SNB

3/8" Lock Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 18-SNB3/8" Lock Washer, Span M19705

CPL 06.02.13



29.0

113803

1/8" PTF Grease Fitting



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ~~113-803~~ 1/8" PTF Grease Fitting, Span M16640 M16533

CPL 06.02.13



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 17 Date: 06/03/01
 QA: N/C Closed: _____ Date: _____

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Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

656036

Inventory



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 ~~656036~~ 5/16" Type B Flat Washer (Narrow), Prof

FW51651

19611
M79611

CPL 06-02-23



31.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last.

CPL 06-02-27

32.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C206102128

①

Job Completion



LEVEL 21 INSPECTION

U 0603-01

D 06103101

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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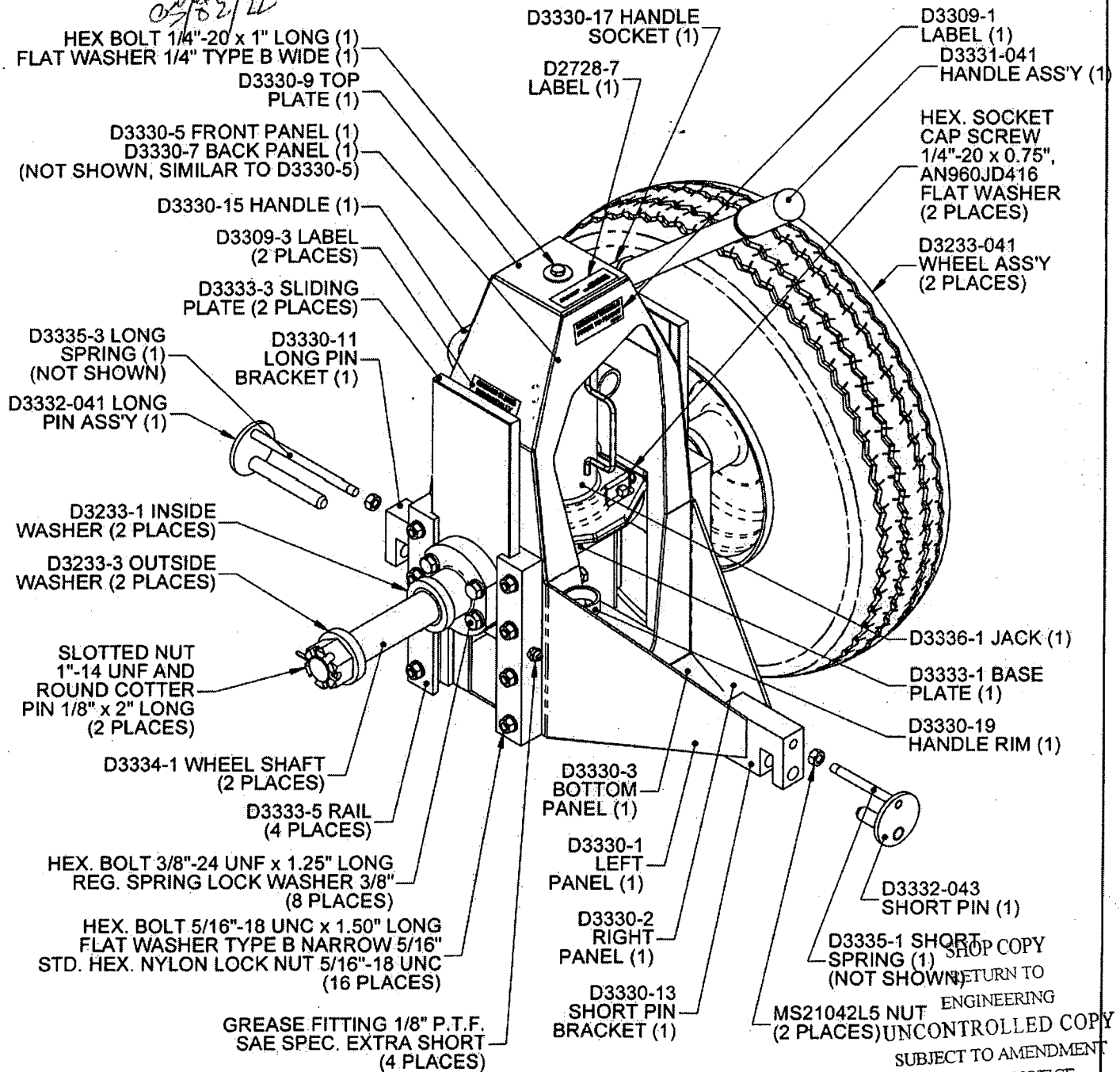
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DART

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSK 092	REV. B SHEET 1 OF 1
DATE 05.02.18		TITLE HYD. GROUND HANDLING	SCALE 1:5
A	04.12.06	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	

RELEASED

03/02/22**NOTE:**

1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE. WORK ORDER
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.

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